

# Assembly instruction

## Series QLA

## No. 3089

### Tools and materials required:

Soldering iron, 70 Watts, 220° to 240°C  
Solder Sn/Pb 60/40, 0.6 mm dia.  
activated rosin flux  
Stanley blade  
2 spanners 5,5 mm  
Crimping tool with insert A

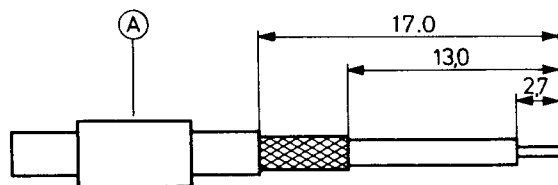
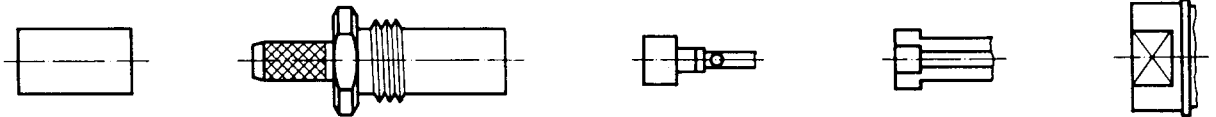
### Straight cable connectors for flexible cable

**Cable entry:** SUHNER crimp

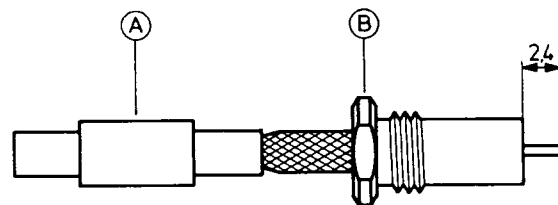
#### Connector types: (e.g.)

11 QLA-01-1-1c	21 QLA-01-1-1c	24 QLA-01-1-1c
11 QLA-01-2-1c	21 QLA-01-2-1c	24 QLA-01-2-1c
11 QLA-01-2-4c	21 QLA-01-2-4c	24 QLA-01-2-4c

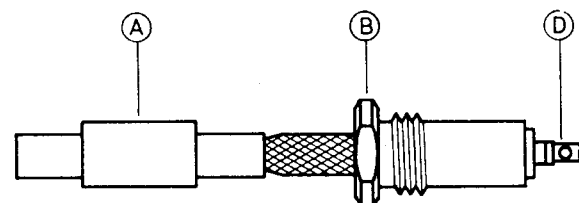
This connector  
is supplied  
in 5 parts



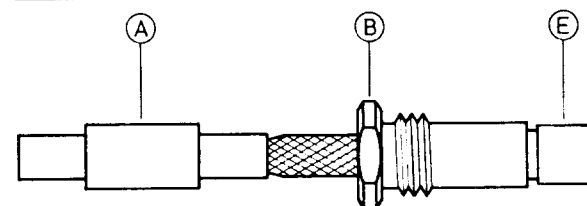
Slide ferrule A onto cable, prepare cable according to diagram. Do not damage inner conductor and screen.



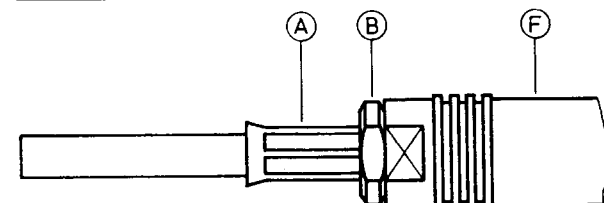
Slide spigot of part B underneath braid until inner conductor protrudes 2.4 mm.



Tin inner conductor of cable and bore hole of contact pin D (70 W soldering iron). Slide on contact D. Heat contact pin D and introduce inner conductor of cable. Remove soldering iron quickly in order to avoid heat damage to cable dielectric. Surface of contact pin D must remain clean.



Slide insulator E over contact pin D (if not already placed in body F).



Screw together body parts F and B and tighten using two 5.5 mm spanners. Slide ferrule A over screen to abut part B and crimp close to connector body.



SUHNER's skilled staff and specialised equipment are available to carry out complete R.F. lead-assembly on your behalf. We mount your connectors on cables at economic prices! Please contact our representative for further details of this service.



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